

AMENDMENTS TO THE CLAIMS:

This listing of claims will replace all prior versions, and listings, of claims in the application:

LISTING OF CLAIMS:

1. (previously presented) Method for producing a multiply web of flexible material, at a plurality of glue sites, which comprises:

by gluing the plies bringing a patterned glue transfer roll, having a pattern of protuberances, in contact with a glue application device;

transferring glue to a first web shaped flexible material in a glue pattern corresponding to the configuration of the protuberances;

bringing a second web shaped flexible material in contact with the glue applied side of said first web shaped flexible material in a press nip between a patterned lamination roll and an impression roll; said lamination roll having a pattern of protuberances corresponding to said glue pattern; the glue transfer roll and the lamination roll being in register with each other, so that the first and second web shaped flexible materials are combined and glued together in a pattern corresponding to the configuration of the protuberances of the glue transfer roll,

wherein the first web shaped flexible material is printed with a printed pattern by a printing roll carrying a colorant in a selected pattern, wherein the printing occurs before the first web shaped flexible material is laminated to the second web shaped flexible material and the printed pattern is printed on an inner side of the first web shaped flexible material facing the second web shaped flexible material; wherein said printing is performed in register with the glue transfer while the first web shaped flexible material is residing on said impression roll, and wherein the printing and the glue transferring are separate and discrete steps effectuated by separate structures.

2. (cancelled)

3. (previously presented) Method as claimed in claim 1, wherein two or more patterns are printed in subsequent steps on said first web shaped flexible material before it is laminated to the second web shaped flexible material, said patterns being printed in register with each other and with the glue pattern.

4. (previously presented) Method as claimed in claim 1, wherein said second web shaped flexible material is printed after or simultaneously with the lamination to the first web shaped

flexible material, wherein the colored printed pattern is printed on the outside of the second web shaped flexible material.

5. (original) Method as claimed in claim 4, wherein two or more patterns are printed in subsequent steps on said second web shaped flexible material after or simultaneously with the lamination to the first web shaped flexible material, said patterns being printed in register with each other and with the glue pattern.

6. (previously presented) Method as claimed in claim 1, wherein at least two printing stations are provided; at least one first printing station prints at least one first pattern on the first web shaped flexible material before it is laminated to the second web shaped flexible material; and at least one second printing station prints at least one second pattern on the second web shaped flexible material after lamination to the first web shaped flexible material.

7. (original) Method as claimed in claim 1, wherein the glue is a coloured glue, and a coloured glue pattern will appear as a printed pattern.

8. (previously presented) Method as claimed in claim 7, wherein a printing pattern is the same as the colored glue pattern and printed on the second web shaped flexible material just on top of the coloured glue pattern on the first web shaped flexible material.

9. (original) Method as claimed in claim 8, wherein said printing pattern and said glue pattern are of different colour.

10. (previously presented) Method as claimed in claim 6, wherein the at least one first printing pattern and the at least one second printing pattern are different.

11. (original) Method as claimed in claim 7, wherein the coloured glue pattern and the printing pattern are different.

12. (original) Method as claimed in claim 1, wherein the size of each glue site amounts to between 0.15 and 150 mm².

13. (original) Method as claimed in claim 1, wherein the number of glue sites per unit area amounts to between 25 per m² to 150 per cm².

14. (original) Method as claimed in claim 1, wherein the pattern configuration of the glue transfer roll is chosen so that glue is applied to said first ply in glue sites covering an area corresponding to between 0.03 and 9% of the total area of the first web shaped flexible material and sparsely distributed over substantially the entire area of the first web shaped flexible material.

15. (original) Method as claimed in claim 1, wherein at least one of the plies before lamination with the opposite ply is exerted to a three dimensional patterning provided on the ply while wet, during drying of the wet ply and/or in dry state.

16. (original) Method as claimed in claim 1, wherein the multi-ply web after lamination is embossed.

17. (original) Method as claimed in claim 1, wherein any of said web shaped flexible materials comprises one or more plies of flexible material.

18-32. (cancelled)

33. (new) A method for producing a multi-ply web of flexible material, at a plurality of glue sites, comprising the steps of:

transferring glue from a patterned glue transfer roll having a pattern of protuberances to a first web shaped flexible material in a glue pattern corresponding to the configuration of said protuberances;

laminating a second web shaped flexible material with said first web shaped flexible material by bringing said second web shaped flexible material in contact with said glue pattern of said first web shaped flexible material in a press nip between a patterned lamination roll and an impression roll, said lamination roll having a pattern of protuberances corresponding to said glue pattern;

driving said lamination roll in register with said patterned glue transfer roll, so that said first and second web shaped flexible materials are combined and glued together in a pattern corresponding to the configuration of said protuberances of said patterned glue transfer roll;

printing a colorant in a selected pattern on said first and/or said second web shaped flexible material to form a colored printed pattern on said first and/or second web shaped flexible material, said printing performed by a printing roll carrying said

colorant, absent glue, and in said selected pattern while said first and/or said second web shaped flexible material is residing on said impression roll; and

driving said printing roll in register with said patterned glue transfer roll, so that said colored printed pattern is in a fixed relationship with said glue pattern on said first web flexible material.

34. (new) The method of claim 33, wherein,
said printing step is completed prior to said laminating step, and

said colored printed pattern is printed on the inner side of said first web shaped flexible material facing said second web shaped flexible material.

35. (new) The method of claim 34, comprising further the steps of:

printing a colorant in a selected pattern on the inner side of said first web shaped flexible material facing said second web shaped flexible material to form an additional colored printed pattern on said first web shaped flexible material before laminating to the second web shaped flexible material, wherein,

said printing step forming said additional printed pattern may be subsequently repeated one or more times to form two or more additional printed patterns, and said additional printed patterns are in register with each other and with said glue pattern, so that said additional printed patterns and said glue pattern have a fixed relationship with one another.

36. (new) The method of claim 33, wherein,

said printing step is completed on said second web shaped flexible material after or simultaneously with said laminating step such that a colored printed pattern is located on the outside of the second web shaped flexible material.

37. (new) The method of claim 36, comprising further the steps of:

printing a colorant in a selected pattern on said second web shaped flexible material after or simultaneously with said laminating step such that an additional colored printed pattern is located on the outside of the second web shaped flexible material, wherein,

said printing step forming said additional printed pattern may be subsequently repeated one or more times to form two or more additional printed patterns, and said additional printed

patterns are in register with each other and with said glue pattern, so that said additional printed patterns and said glue pattern have a fixed relationship with one another.

38. (new) The method of claim 34, comprising further the step of :

printing a colorant in a selected pattern on said second web shaped flexible material after said laminating step such that a colored printed pattern is located on the outside of the second web shaped flexible material.

39. (new) The method of claim 38, wherein,

said colored printed pattern on the inner side of said first web shaped flexible material and said colored printed pattern on the outside of said second web shaped flexible material are different.

40. (new) The method of claim 33, wherein,

said glue is a colored glue, and
a colored glue pattern appears as a printed pattern.

41. (new) The method of claim 40, comprising the further step of:

printing a colorant in a selected pattern on said second web shaped flexible material after or simultaneously with said laminating step, wherein,

said selected pattern is identical to said glue pattern, so that a colored printed pattern is provided on the outside of the second web shaped flexible material and on top of said colored glue pattern on the first web shaped flexible material.

42. (new) The method of claim 41, wherein,

said printing pattern and said glue pattern are of different color.

43. (new) A method for producing a multi-ply web of flexible material, at a plurality of glue sites, comprising the steps of:

transferring glue from a patterned glue transfer roll having a pattern of protuberances to a first web shaped flexible material in a glue pattern corresponding to the configuration of said protuberances;

laminating a second web shaped flexible material with said first web shaped flexible material by contacting said second web shaped flexible material with said glue pattern of said first web shaped flexible material in a press nip between a patterned lamination roll and an impression roll, said lamination roll having a pattern of protuberances corresponding to said glue pattern and said press nip;

driving said lamination roll in register with said patterned glue transfer roll, so that the first and second web shaped flexible materials are combined and glued together in a pattern corresponding to the configuration of said protuberances of said patterned glue transfer roll; and

printing a colorant in a selected pattern on said second web shaped flexible material simultaneously with said laminating step such that a colored printed pattern is located on the outside of the second web shaped flexible material that is in a fixed relationship with said glue pattern.

44. (new) The method of claim 43, comprising the further steps of:

printing a colorant in a selected pattern on said first web shaped flexible material prior to said laminating step, so that a colored printed pattern is located on the inner side of the

first web shaped flexible material facing the second web shaped flexible material.

45. (new) The method of claim 44, wherein,
said printing of said first web shaped flexible material is performed by a printing roll having a selected pattern carrying said colorant, and

said printing roll is in register with said patterned glue transfer roll to provide said colored printed pattern in a fixed relationship with said glue pattern on said first web flexible material.

46. (new) The method of claim 44, wherein,
said printing of said first web shaped flexible material is performed by a patterned glue transfer roll,
said glue is a colored glue, and
said colored printed pattern is a colored glue pattern.